

Date: Monday, 11/08/2008 10:20:21 AM
 User: Linda Lacelle

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 41082 - 1		Part Number	: D35371	
Estimate Number	: 12712		Drawing Number	: D3537 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 11/08/2008 S.O. No. :		Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: 11/08/2008 Type : SMALL /MED FAB		Due Date	: 25/08/2008 Qty: 100 Um: Each	
Previous Run	: 38941				
Written By	:				
Checked & Approved By	: <u>JL</u> 08.8.11				
Comment	: Est Rev:A New Issue 07-02-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
		Comment: Qty.: 0.1113 sf(s)/Unit Total : 11.1300 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>108724</u> HB 8-8-14	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> HB 8-8-14 Prog Rev: <u>C</u>	
		2-Deburr if necessary HB 8-8-14	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-8-14</u>	
4.0	QC8	SECOND CHECK	
		<u>Job 08-18</u> Comment: SECOND CHECK <u>105 counted.</u>	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	
		<u>Sa 08/08/19</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:20:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41082

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 LARGE FAR 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat M108631,108709

1-Weld as per Dwg D35371 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

EL 89-22 (41)

7.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



M106442

(41x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:50

OVEN TEMPERATURE: 323°

FINISH TIME: 8:20

m-f 08/09/23

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1

PACKAGING RESOURCE #1



(41)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

Fx 08/09/23

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/23 (41)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Appreval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41082
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

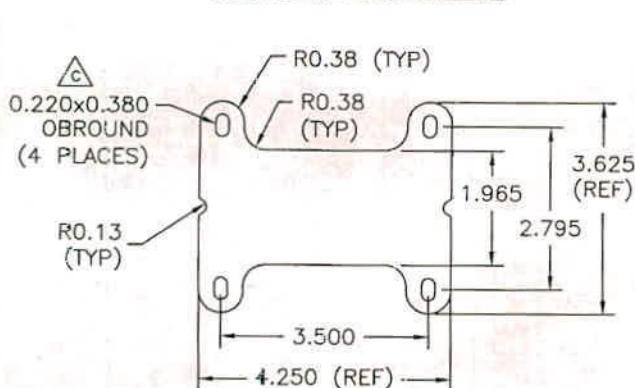
X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>/</u>	Prototype Approval: N/A
Date: <u>8-8-14</u>	Date: <u>08-08-14</u>	Date: N/A

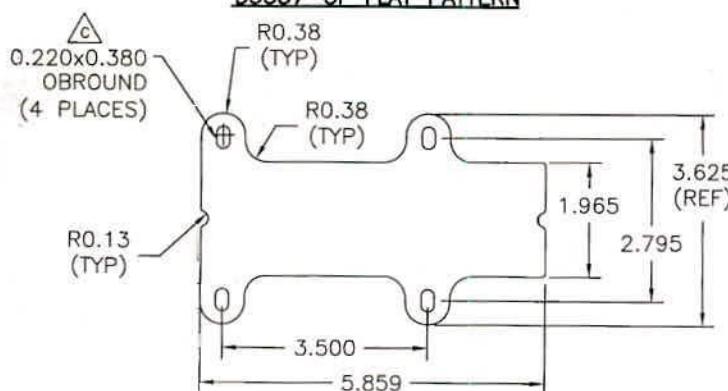
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>



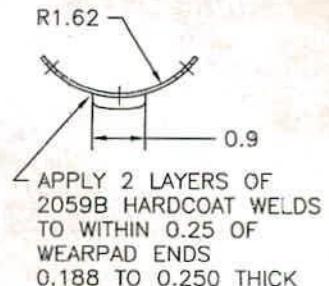
D3537-1F FLAT PATTERN



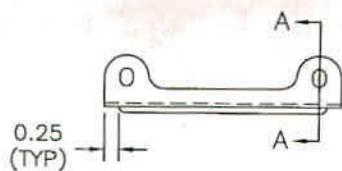
D3537-3F FLAT PATTERN



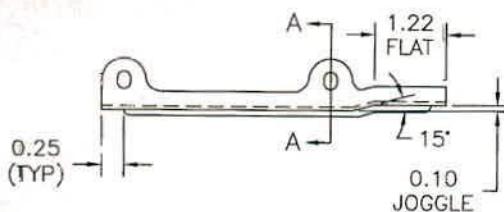
SECTION A-A



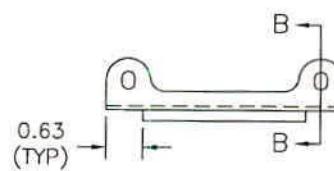
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



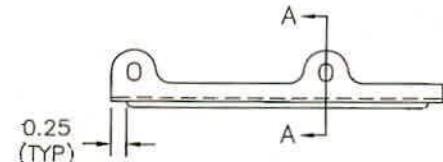
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE ~~PER DART QSI 018~~ UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CB	PH	DART AEROSPACE USA, INC. PORT HULOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE	07.04.13	TITLE WEARPAD
		SCALE 1:2

40-14082
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